Work Orde				*129	3714*							Page 1
	D3573-3			Accept	*N900	040	100)* s		Start		S1*
	Adapter		4.404							Stop	*N	S2*
Start Date: Required Date: Reference:	8/18/14 8/18/14	Start Qty: 10.00 Req'd Qty: 10.00	*10* *10*		Cust Item 1 Customer:	(D:						
Approvals:	Process Plan	n: <u>ML5</u>	Date: 14-08-20	Tooling:	D	ate:	-	R		Start	*N	R1*
	QC:		Date:	SPC (Y/N):	D	ate:				Stop	*N	R2*
Sequence ID/ Work Center II)	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reje Qty		Reject Number	Insp. Stamp
Draw Nbr	Revi	ision Nbr										
D3573	Rev	A										
*100 *100* Bandsaw Jeaspa Bandsaw		BAND SAW Memo Cut blank	3.500" long	0.00				_10_		<u>I</u>		July.
110		HAAS CNC VERTICA	AL MACHINING #1	0.00				, ,] [14]0
110 HAAS 1 HAAS CNC vertica	ıl machine #1	Memo	s per Folio FA673 and Dwg 1	0.00 D3573				10_	,	<i>P</i>		
120		OC2 Inspect parts off		0.00								

0.00

Memo

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Quality Control

DQA:			Date:			. WORK ORDER NON	~			ם אדר			`DART
QA Closed:			Date:			WORK ORDER NON-	-((JNFUI	RIVIAINCE / OI		ork Order up	date only	AEROSPACE
Work Orde) r·					DISPOSITION				AGAINST D	EPARTMENT	/PROCESS	
Part N	-	***************************************				Rework Scrap Use-as-is		i	Skid-tube Machining noforming	Crosstube Small Fab Finishing		Water Jet d. Eng. Coor. e/Packaging	Engineering Quality Other
NCR I	No.				·	Suspected Unapproved		mem	Large Fab	Composite	_ Kec/stor	Supplier	- Other
Root					Desc	ription of work order update	1	nitial	Act	ion	Sign &		
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Descr	iption	Date	Verification	QC Inspector
Design Doc/Data Equip/Tooling Handling/Pre Material Operator Offset/Setup Process Supplier Training Transport Unapproved						·							
							FA	ULT CAT	regory				
Landi		Bending Centre N Cracks Crimp/Kii Cuffs Crushing Heat Trei Inspectio Marks/Cl	nk/Ripple at on Strip in	e/Wave Tube		General Bend BOM/Route Broken/Damage/Defect Burrs Contamination Countersink Cut Too Short Drawing Drill Holes Finish		Grain Hardwa Inspect Instruct Misalia Mislaba Misread Off-set	ion Incomplete/Ur tions Incomplete/U gned/off center eled d	· —	Outside Dim Over/Under Part Incorred Part Lost/Mi Part Moved Positioned V Power Loss/	tolerance ct ssing Vrong	Pressure/Forced Set-up Temperature/Cure Weld Wrong Stock Pulled Other
		Wave/Tv	vist in Tul	be		Fit/Function		Out of	Sequence				

Work Order II) 123714
---------------	----------

123714

Page 2

Insp.

Stamp

DAS

80

9-89

Monday, August 18, 2014 2:37:20 PM D3573-3 Accept Item ID: *N900040100* Setup Start **Revision ID:** Stop **Item Name:** Adapter Start Date: *10* 8/18/14 **Start Oty: 10.00 Cust Item ID:** Required Date: 8/18/14 Req'd Qty: 10.00 *10* **Customer:** Reference: Run Start Process Plan: ____ Date: Tooling: Date: **Approvals:** Stop Date: Date: SPC (Y/N): QC: Tool # Plan Operation Set Up/ Tool ID Reject Reject Sequence ID/ Accept Qty Oty Number **Work Center ID** Code **Description Run Hours** QC8- Inspect parts - second check 0.00 130 109/03 10 \$ *130* 0.00 OC Memo Quality Control 0.00 Chemical Conversion Coat per QSI005 4.1 140 10 7614-9.4 *140* HandFinish 0.00 Memo Hand Finishing Grey Sandtex(Ref:4.3.5.6) per QS1005 4.3 150 0.00 D & 14-8-4 *150* Powdercoat Memo START TIME: FINISH TIME: Powder Coating

update only
T/PROCESS
Water Jet Engineering Od. Eng. Coor. Quality
ore/Packaging Other Supplier
Verification QC Inspector
mensions Pressure/Forced Set-up Temperature/Cure Weld d Wrong Stock Pulled Wrong S/Surge Other
e r N

Work Ord Monday, Augus				*129	R714*							Page 3	
Item ID: Revision ID: Item Name:	D3573-3 • Adapter		,	Accept	*N900	040	100)*	Setup	Start Stop	*N *N	S1* S2*	
Start Date: Required Date Reference:	8/18/14 : 8/18/14	Start Qty: 10.00 Req'd Qty: 10.00	*1		Cust Item II Customer:	D:				G			
Approvals:	Process Pl	lan:	Date:	Tooling:	Da	ite:			Run	Start	*N	R1*	
	QC:		Date:	SPC (Y/N):	Da	nte:				Stop	*N	R2*	
Sequence ID/ Work Center I 160 *160* QC Quality Control	D	Operation Description QC3- Inspect Part Finish Memo		Set Up/ Run Hours 0.00	Tool ID	Tool#	Plan Code	Accep Qty	Qt		Reject Number	Insp. Stamp	>د
170 *170* Packaging Packaging		Identify as per dwg & Sto	ock Location	0.00 0.00				C) K		V	499	<u></u>

0.00

0.00

MUD 14-09-08 UMF 14-9-5

QC21- Final Inspection - Work Order Release

Memo

180

1 20

Quality Control

DQA:			Date: _					DART						
QA Closed:			Date:		•	WORK ORDER NON	-CC	ONFO	RMANCE / UF		ork Order up	date only	AEROSPACE	
						DISPOSITION				AGAINST DE	PARTMENT	/PROCESS		
Work Orde	er: -					_ ,	,		a	C	٦ .	Water let	T Fusingswing	
0 1					,	Rework	1		Skid-tube	Crosstube Small Fab	Bro	Water Jet d. Eng. Coor.	Engineering Quality	
Part N	10					Scrap Use-as-is	1 1		Machining	Finishing	┥	e/Packaging	Other	
NCR N	lo.					Suspected Unapproved	1	IIICIII	Large Fab	Composite	1 1100,010.	Supplier		
	-						_							
Root					Desc	ription of work order update		nitial	Acti	ion	Sign &			
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Descr	iption	Date	Verification	QC-Inspector	
Design			,											
Doc/Data			17.			•								
Equip/Tooling				-										
Handling/Pre	_		:											
Material	_		<u> </u>			·								
Operator			!											
Offset/Setup	-		ļ								:			
Process						,								
Supplier													<i>'</i>	
Training Transport														
Unapproved			ļ				1							
опаррготеа		<u></u>	1	L	I		FA	ULT CA	TEGORY	<u></u>		7		
Landir	ng (ear				General								
	_	Bending				Bend		Folio/F	Program		Outside Dim	ensions	Pressure/Forced	
		Centre No	ot Concer	ntric		BOM/Route		Grain			Over/Under	tolerance	Set-up	
		Cracks				Broken/Damage/Defect		Hardwa	are		Part Incorre	cí	Temperature/Cure	
		Crimp/Kiı	nk/Ripple	/Wave		Burrs		Inspect	ion Incomplete/Ur	nqualified	Part Lost/Mi	issing	Weld	
		Cuffs				Contamination		Instruc	tions Incomplete/L	Jnclear	Part Moved		Wrong Stock Pulled	
		Crushing				Countersink		Misali	gned/off center		Positioned V	_		
		Heat Trea	at			Cut Too Short		Mislab	eled		Power Loss/	Surge	Other	
		Inspectio	n Strip in	Tube		Drawing	\perp	Misrea						
		Marks/Cl	natter			Drill Holes		Off-set						
		Turning S				Finish		4	Calibration		 		· · · · · · · · · · · · · · · · · · ·	
		Wave/Tw	vist in Tub	oe		Fit/Function	\perp	Out of	Sequence					

Monday, August 18, 2014 2:37:20 PM

Work Order ID: 123714 ^-

123714

Parent Item:

D3573-3

D3573-3

Parent Item Name: Adapter

Start Date: 8/18/14

Required Date: 8/18/14

Start Qty: 10.00

**

Required Qty: 10.00

Comments:

IPP Rev:A New Issue 07-01-29 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Primary Item Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B0.500X02.50	_	Purchased	No		100	f	28.2630	0.292	3.073684	1		

M6061T6B0 500X02 500

Location	Loc Oty	Loc Code
MAT001	28.263	
124443	. 2	
→ M128247	14.263	
M129972	12	

DQA:			Date:								•		TRAC
QA Closed:			Date:			WORK ORDER NON-	-CC	ONFO	RMANCE / UPDATE	W	ork Order up	odate only	AEROSPACE
						DISPOSITION			AGAIN	ST DE	PARTMENT	/PROCESS	
Work Orde	er: _										1	\4/a4am.1a4	
Part N	1o				_	Rework Scrap			Skid-tube Crosstul Machining Small Fanoforming Finishin	ab	4	Water Jet d. Eng. Coor. e/Packaging	Engineering Quality Other
NCR N	No					Use-as-is Suspected Unapproved		men	Large Fab Composi	- * }—	, Recystor	Supplier	Other
Root					Desci	iption of work order update		nitial	Action		Sign &		
Cause	- 1	Date	Step	Qty		or non-conformance	Ch	ief Eng	Description		Date	Verification	QC Inspector
Design					•								
Doc/Data													
Equip/Tooling			1										
Handling/Pre							l						
Material			1										
Operator													
Offset/Setup													
Process													
Supplier											ļ		-
Training													
Transport													
Unapproved													
							FAI	ULT CA	TEGORY				
Landi	ng G	ear				General		_			_		
		Bending				Bend		Folio/f	Program	L	Outside Dim	ensions	Pressure/Forced
		Centre No	t Conce	ntric		BOM/Route		Grain			Over/Under	tolerance	Set-up
	\Box	Cracks				Broken/Damage/Defect		Hardwa	are		Part Incorre	cí _	Temperature/Cure
	П	Crimp/Kir	ık/Ripple	/Wave		Burrs		Inspect	ion Incomplete/Unqualified		Part Lost/Mi	ssing	Weld
	\Box	Cuffs				Contamination		Instruc	tions Incomplete/Unclear		Part Moved		Wrong Stock Pulled
	\prod_{i}	Crushing				Countersink		Misali	gned/off center		Positioned V		
		Heat Trea	it			Cut Too Short		Mislab	eled		Power Loss/	Surge	Other
		Inspection	n Strip in	Tube		Drawing		Misrea	d			<u></u>	
	П	Marks/Ch	atter			Drill Holes		Off-set					
	\square	Turning S	equence	!		Finish		Out of	Calibration				
	П	Wave/Tw	ist in Tul	be		Fit/Function		Out of	Sequence				

DART AEROSPACE LTD	Work Order:	123714
Description: Adapter	Part Number:	D3573-3
Inspection Dwg: D3573 Rev: A	•	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

	X	First Art	icle	Prototype
		Antual		

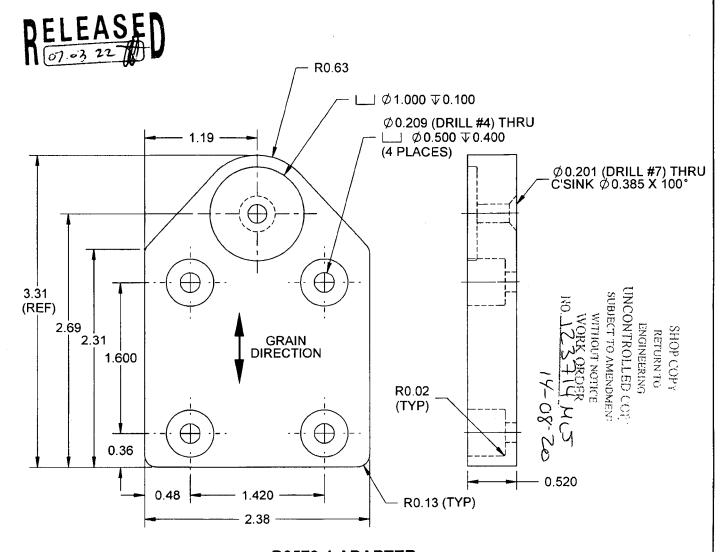
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.31	+/-0.030	3 311			MJP-04	Vern
2.69	+/-0.030	2 690	1/		1 1 1	,
2.31	+/-0.030	2 310	/			
1.600	+/-0.005	1600				
0.36	+/-0.030	0.359			4	1
1.19	+/-0.030	1 186	/		3100 6	Hight ears
2.38	+/-0.030	j, 375	/		MJP-04	Vern
1.420	+/-0.010	1,419	1/		10	,,,
0.48	+/-0.030	0, 478	/		64.	٠,,
R0.63	+/-0.030	0,630	/		A-	Radius garey
R0.13	+/-0.030	0, 130	/		///	
R0.02	+/-0.030	0,020	V		113	7.1.1
Ø0.209	+0.005/-0.001	0,211	/		MJP.04	Vern
Ø0.266	+0.006/-0.001	0 268	/		115	
0.390	+0.010/-0.000	0 397				
Ø0.675 x 0.190	+/-0.010	0.675 x189				
Ø0.500 x 0.310	+/-0.010	0, 268 0, 397 0, 675 ×189 0, 497×0,308	/		4	4
			,			

Measured by:	Audited by:	13.0	DAS OS	Prototype Approval:	N/A
Date: 14/02/02	Date:	14/09/03	9-89	Date:	N/A

Rev		Change	Revised by	Approved
Α	07.04.04	New Issue	KJ/JLM	
			()	/ /



DESIG	N	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECK	(ED	APPROVED	DRAWING NO.	F	REV. A
6	214	1	D3573	SHEET	1 OF 4
DATE			TITLE		SCALE
07.02.19		ADAPTER		1:1	
REV		DATE		DESCRIPTION	
Α		07.02.19	NEW ISSUE		



D3573-1 ADAPTER

NOTES

1) MATERIAL: 6061-T6 (OR T651/T6510/T6511/T62) ALUMINUM BAR

PER QQ-A-225/8 OR QQ-A-200/8 OR AMS 4117/4128/4115/4116 OR AMS 4160

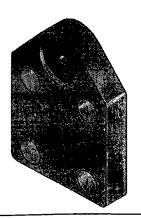
(REF DART SPEC M6061T6B)

2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "GREY SANDTEX" (4.3.5.6) PER DART QSI 005 4.3
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
4) IDENTIFY WITH DART P/N "D3573-1" USING FINE POINT PERMANENT INK MARKER
5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX



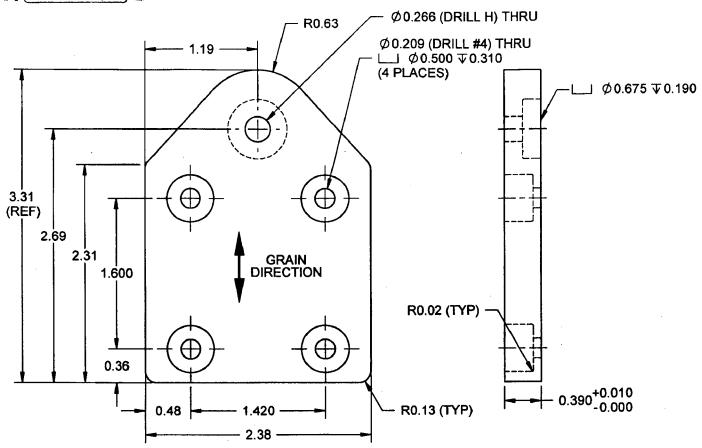
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CHECKED	APPROVED	DRAWING NO.	REV. A
PH	- til	D3573	SHEET 2 OF 4
DATE		TITLE	SCALE
07.02.19		ADAPTER	1:1





D3573-3 ADAPTER

NOTES

1) MATERIAL: 6061-T6 (OR T651/T6510/T6511/T62) ALUMINUM BAR

PER QQ-A-225/8 OR QQ-A-200/8 OR AMS 4117/4128/4115/4116 OR AMS 4160

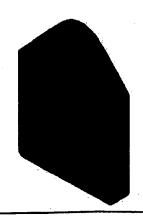
(REF DART SPEC M6061T6B)

2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

POWDER COAT "GREY SANDTEX" (4.3.5.6) PER DART QSI 005 4.3
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

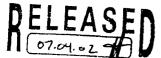
4) IDENTIFY WITH DART P/N "D3573-3" USING FINE POINT PERMANENT INK MARKER

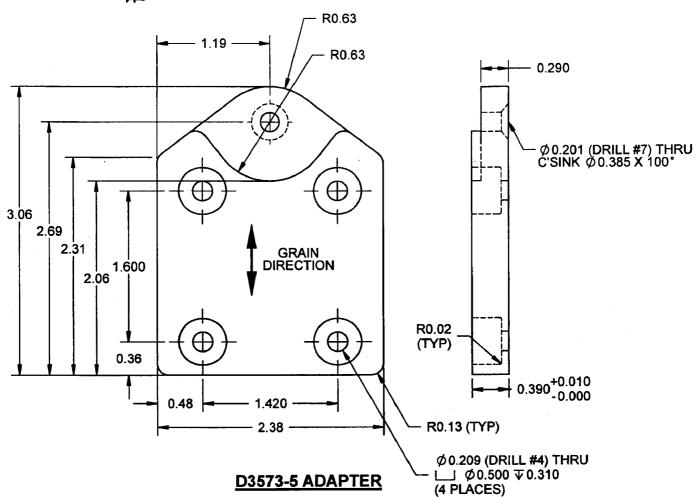
5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX





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CHECKED	APPROVED	DRAWING NO.	REV. A
PH		D3573	SHEET 3 OF 4
DATE		TITLE	SCALE
07.02.19		ADAPTER	1:1





1) MATERIAL: 6061-T6 (OR T651/T6510/T6511/T62) ALUMINUM BAR PER QQ-A-225/8 OR QQ-A-200/8 OR AMS 4117/4128/4115/4116 OR AMS 4160

(REF DART SPEC M6061T6B)

2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

POWDER COAT "GREY SANDTEX" (4.3.5.6) PER DART QSI 005 4.3

3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

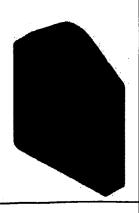
4) IDENTIFY WITH DART P/N "D3573-5" USING FINE POINT PERMANENT INK MARKER

5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

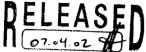


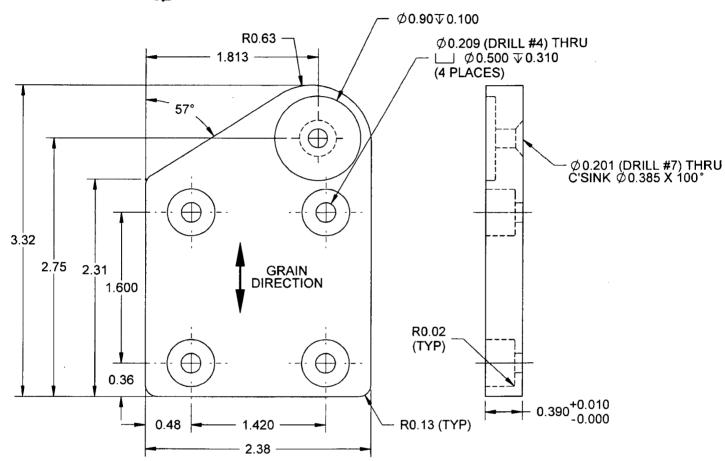
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DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. A
PH		D3573	SHEET 4 OF 4
DATE		TITLE	SCALE
07.02.19		ADAPTER	1:1





D3573-7 ADAPTER (SHOWN) D3573-8 ADAPTER (OPPOSITE)

1) MATERIAL: 6061-T6 (OR T651/T6510/T6511/T62) ALUMINUM BAR

PER QQ-A-225/8 OR QQ-A-200/8 OR AMS 4117/4128/4115/4116 OR AMS 4160

(REF DART SPEC M6061T6B)

2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

POWDER COAT "GREY SANDTEX" (4.3.5.6) PER DART QSI 005 4.3
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

4) IDENTIFY WITH DART P/N "D3573-7/-8" USING FINE POINT PERMANENT INK MARKER

5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX



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